



Dart Aerospace Ltd.
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POSITIVE RECALL

EFFECTIVE 19/07/11 AUTH SAD

RELEASED DAS DATE MAR 3 1 2020
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9-89

6F9540V00231

Sheet 197323

MAR 3 1 2020

Part No: 6F9540V00231

Job Qty: 1 pcs

Part Name: AW169 Lower Cutter Installation Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/4/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 3/2/20

Type: SOLD

Description:

Note: URF16-692 DWG IIN-D169-841 REV D IPP REV:A 13.11.13 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Packaging 1 - Pick Kit	1 pcs	3/2/20		0.00	0.00	Packaging 1 - 1		 197323 19/07/11
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		
							Packaging 1 - 31		

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Container No: S267140

Part: 6F9540V00231

Job No: 197323

Serial No/Batch: S267140

Revision: D

Inspector:

Exp Date:

Instructions:

Date: 03/27/20

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					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	
105 QC 4	1 pcs	3/2/20	0.00 0.00		QC 4 - 28	
					QC 4 - 58	
					QC 4 - 69	
					QC 4 - 9	
					QC 4 - 46	
					QC 4 - 68	
					QC 4 - 72	
					QC 4 - 74	
					QC 4 - 75	
120 Packaging 3-1 - Stock - B4B	1 pcs	3/2/20	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
125 DC - 1 - B4B	1 pcs	3/2/20	0.00 0.00		DC - 1 - B4B	
					DC - 2 - B4B	
130 QC 21 - FG	1 pcs	3/2/20	0.00 0.00		QC 21 - FG - 21	
					QC 21 - FG - 70	
					QC 21 - FG - 53	

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MAR 3 1 2020

9-88rt Op 100 - (Pick Kit)

Descriptions: 105 - (QC4- 100% Inspect kits for completeness)

120 - Identify and pack for shipping as per PPP 6F9540V00231

125 - Photocopy blue file per PPP D169-841-015 chg002 and create labels per 6F9540V00231 CHG002

130 - QC21- Final Inspection - Work Order Release

Location concession *

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D169-841-015	AW169 Lower Cutter	1 pcs (1 ea)	100-Packaging 1 - Pick Kit	S248310.v1
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Packaging 1 - Pick Kit	D169-841-015	1	0	0
Part Specifications				
Specifications could not be found.				

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		Concessione Fornitore			PAGINA 1 di 2	STAB. EMITTENTE Vergiate	
NC Fornitore N.	AWC-040	Data	02.04.2020	Concessione	400000090700	Ordine	4801939434
P/N	6F9540V00231			Grado/Categoria	NC	Rev. disegno	
Descrizione Parte	PROTECTR, CCP ASSY LOWER			Quantità Lotto	1,000	Q.tà sotto conc.	1,000
Coordinatore NC	GIORGIO BENZONI					A/C Model	AW6
Fornitore	DART AEROSPACE LTD					Contratto	
Difetto MA01 - Materiale diverso dal richiesto - * 02.04.2020 17:19:24 GIORGIO BENZONI (39851) * See supplier concession AWC-040 attached Causa del Difetto							
					Ripetività (stesso P/N-Cod.Difetto)	NO ☐	SI ☒ (17)
Valutazioni e proposte dell'ENGINEERING							
Valutazioni dell'Engineering compresi input dell'Esperto:				Rapp. Indagine n.	Rapp. Rispondenza n.		
* 15.04.2020 14:52:37 GENNARO MARGIOTTA (5907) * The part is acceptable with the proposal of rework applied. * The rework will not have any affect on the functional and on strenght requirements, see the statement in the attached supplier document. Classificazione Deviazione dal Type Design secondo EASA part 21A.91: Minore/B							
Effetti del difetto				Limitazioni			
	Prima eventuale riparazione		Dopo eventuale riparazione		☐ Si (specificare) ☒ NO		
Sicurezza	☐ SI	☐ SI ☐ No					
Vita o durata	☐ SI	☐ SI ☐ No					
Resistenza	☐ SI	☐ SI ☐ No					
Prestazioni	☐ SI	☐ SI ☐ No					
Intercambiabilità	☐ SI	☐ SI ☐ No					
Affidabilità	☐ SI	☐ SI ☐ No					
Manutenibilità	☐ SI	☐ SI ☐ No					
Installabilità	☐ SI	☐ SI ☐ No					
Testabilità	☐ SI	☐ SI ☐ No					
Solo aspetto	☐ SI	☐ SI ☐ No					
Nessun effetto	☒ SI	☐ SI ☐ No					
Proposte di recupero:				Decisione di Impiego			
* 15.04.2020 14:52:37 GENNARO MARGIOTTA (5907) * See attached supplier's proposal and statment.				☐ Usare riparato con riparazione specifica ☒ Usare riparato con riparazione nota ☐ Usare com'è ☐ Usare riparato per prove (vedi Limitaz.) ☐ Usare com'è per prove (vedi Limitazioni) ☐ Scartare			
Classificazione Concessione		☐ MAGGIORE ☒ MINORE	Ripresentare dopo riparazione		☐ SI ☒ No		
Marcatura		☒ NO ☐ SI Metodo :					
ATE	GENNARO MARGIOTTA		CPE			Data	15.04.2020
Verifiche e prove da effettuare							
Registraz. della riparazione		Con Ordine (WO) di riparazione ☒		Numero:			
Valutazione Riparazione:							
Decisioni finali							
S/N	Usare com'è (UTI)	Usare riparato (RIL)	Scartare (SCA)	S/N	Usare com'è (UTI)	Usare riparato (RIL)	Scartare (SCA)
S267140	☐	☒	☐		☐	☐	☐
	☐	☐	☐		☐	☐	☐
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	☐	☐	☐		☐	☐	☐
	☐	☐	☐		☐	☐	☐
Non Serializzati	Q.tà Usare com'è	Q.tà Usare riparato	1,000	Q.tà Scartare			
Funzione	ATE/AW	CPE AW	Verifica della Riparazione	Qualità	Cliente	MOD/Rappresent. Istituzionale	
Firma	GENNARO MARGIOTTA						
Data	15.04.2020						

NC Fornitore N.	AWC-040	Data	02.04.2020	Concessione	400000090700	Ordine	4801939434
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CAUSE DEL DIFETTO

- C8C5 Metodo e Processi

Concession	QRS-107_F01 Issue 02	Page 1/3
	June 2018	

Supplier NC Number	AWC-040	Date	March 31, 2020	LH NC Number	400000090700	Purchase Order	4801939434
LH PN	6F9540V00231	S/N / Batch N.	S267140	Grade/Criticality	NC	LH DWG issue	B
P/N Description	Protector, CCP Lower Assembly			Batch Qty	1	Defective Qty	1
Supplier Name	Dart Aerospace LTD					Model	AW169

Defect(s) Description

1. Leonardo has informed Dart that there are interference issues installing the lower cable cutter D4842-041 (D4842-3 and D4842-4)onto the Leonardo interface bracket.
2. The grain direction on the D4842-1 (D4842-041 Lower Cutter Deflector), Deflector was deviated from the approved Data. The proposed change to the drawing is attached in engineering evaluation.

Department	Inspector	Signature	Date
Quality Assurance	DAS 9	<i>[Signature]</i>	March 31, 2020

Defect(s) Cause

1. The Lower Cutter body has a dimension of 0.43 +0.01/-0.00. This dimension was reported as part of the approved FAI and has been met with all delivered product.
2. Dart Hawkesbury Design Engineer has modified the approved drawing to allow for manufacturing to minimize in material waste.

Department	Inspector	Signature	Date
Quality Assurance	DAS 9	<i>[Signature]</i>	March 31, 2020

Concession	QRS-107_F01 Issue 02	Page 2/3
	June 2018	

Corrective Action				
Dart requests Leonardo Helicopters to accept the modified parts as described in this Concession. Dart is in the process of updating the drawings for approval by Leonardo Helicopters for future production.				
Department	Inspector	Signature	Date	Foreseen implementation date
Quality Assurance	DES 9	<i>[Signature]</i>	March 31, 2020	

S-88

For Suppliers approved as "MANUFACTURER" only

Supplier ENGINEERING evaluation and proposal

Investigation Report

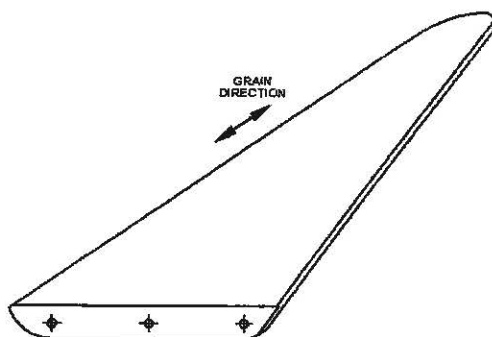
n: NCR17-6591

Compliance Report

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1. Dart's position is that this change will not impact the structural substantiation presented in Report DA169-4 for the lower cutter body since this is not a section with the lowest margin. Therefore removing 0.010" from each part will not impact the structural integrity of the lower cutter assembly. With the tolerance stack-up the lower cutter body would measure 0.84" (21.34 mm) to 0.88" (22.35 mm) which provides an additional 0.002" for variance of the sealant.
2. Grain direction was rotated 56° to align with the leading edge of the deflector. This orientation allows for a smaller raw material blank size and significantly reduce material scrap. The grain direction is still effectively perpendicular to the bending plane from cable loads. The effect on strength is insignificant.



Defect Effects			Limitations after repair
	Before any repair	After any repair	
Safety	☐ yes	☐ yes ☐ no	☐ yes (specify) ☐ no
Life	☐ yes	☐ yes ☐ no	
Strength	☐ yes	☐ yes ☐ no	
Performance	☐ yes	☐ yes ☐ no	
Interchangeability	☐ yes	☐ yes ☐ no	
Reliability	☐ yes	☐ yes ☐ no	
Maintainability	☐ yes	☐ yes ☐ no	
Installability	☐ yes	☐ yes ☐ no	
Only Aspect	☐ yes	☐ yes ☐ no	
Repair Proposal			